

Work Order ID 91159

October-03-12 9:07:31 AM

91159

Page 1

Item ID: D3286-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 03/10/2012 Start Qty: 120.00

120

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: ML3

Date: 12-10-03 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3286	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3286								
304.125"	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
15
12/11/20

(150) B12-11-8
(150) B12-11-8
150
CWA

Work Order ID 91159

October-03-12 9:07:31 AM

91159

Page 2

Item ID: D3286-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 03/10/2012 Start Qty: 120.00

120

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3286	0.00 0.00				150			SB 12/1/21
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	AS 15 2-83	21-21		150 Ceen			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>46</i> Memo ***STOCK IN SKIDTUBE CELL***	0.00 0.00							DP 12-11-22

Work Order ID 91159

October-03-12 9:07:31 AM

91159

Page 3

Item ID: D3286-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 03/10/2012 Start Qty: 120.00

120

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/11/22 JF
MK
12-11-22

Picklist Print

October-03-12 9:07:34 AM

Page 1

Work Order ID: 91159

91159

Parent Item: D3286-1

D3286-1

Parent Item Name: Doubler

Start Date: 03/10/2012

Required Date: 05/12/2012

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP A04.07.14New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	197.0000	0.0749	9.461053			

M304S11GA

304/316 0.125 Sheet

**

12-11-8

Location

Loc Qty

Loc Code

MAT020

197

122521

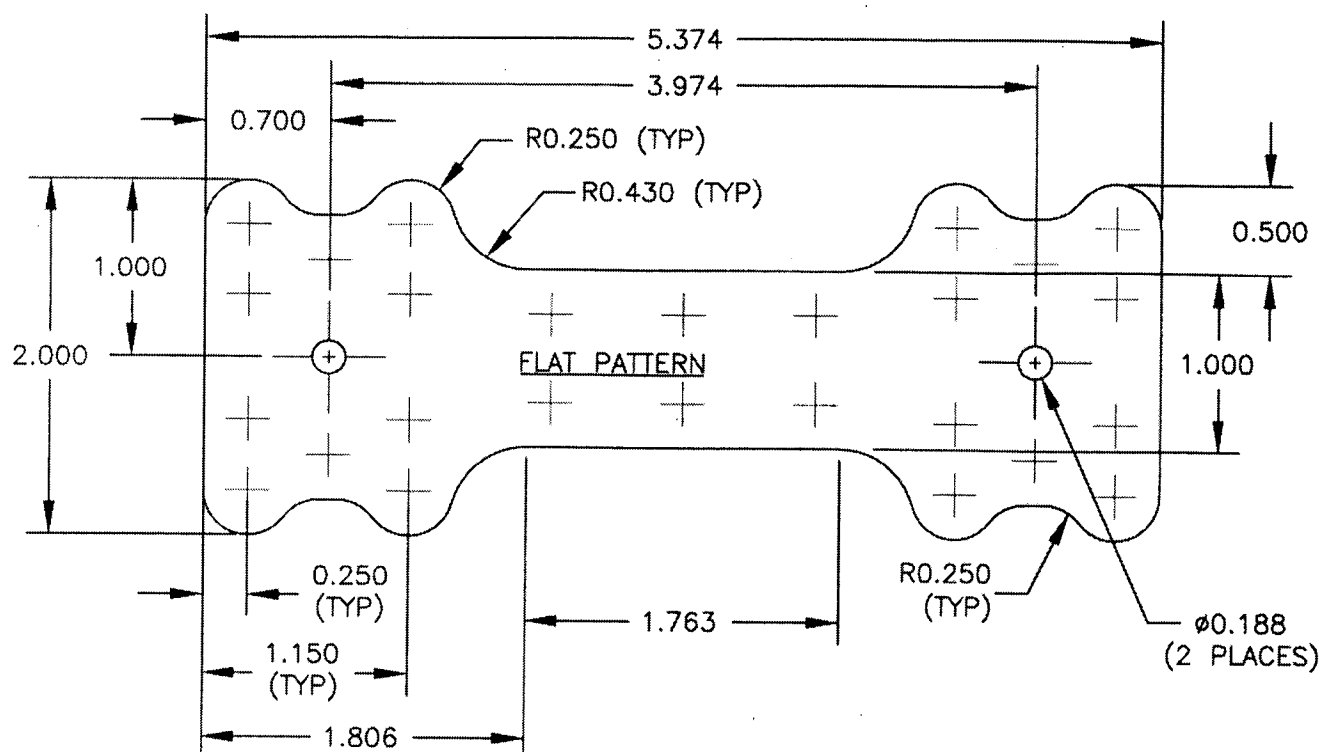
197

122521

(150)



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.

BENDING DETAIL

R1.51

RELEASED
04.06.22

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 91159 M65

12-10-03

D3286-1 DOUBLER

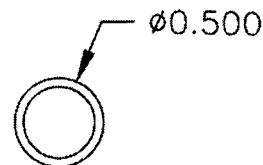
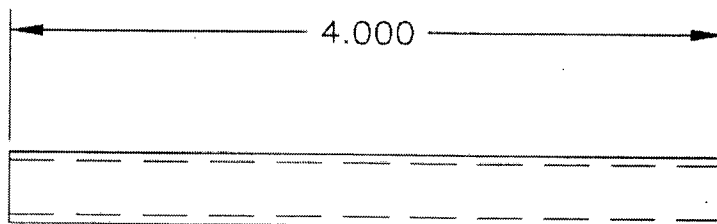
- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *[Signature]*

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91159